

Work Order ID 55819

Tuesday, February 02, 2010 1:50:29 PM

Page 1

Item ID: D412-630-031

Accept

Setup Start

Revision ID:

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Stop

Start Date: 2/3/2010 Start Qty: 6.00

Required Date: 2/15/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-2-2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

8/10/02/18

HG BG 10/02/10

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

8/10/02/18 (6)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

****ensure tension to retract step is 11 to 18 lbs ****

8/10/02/18

(16)
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 2/3/2010 Start Qty: 6.00

Required Date: 2/15/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-2-10

sl

(6x)

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S.10.12/18

(H6)
(CM)

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-031

Location: 31PPP Rev: C

10-2-18

sl

(6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 2/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/18 JF

MF

10-2-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 2/15/2010

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN310-4		Purchased	No			130	Each	71.0000	6.0000			



NUT

10-2-10

sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

71

112969

9

113422

12

113845

50

6

AN310-5



NUT

Purchased

No

130

Each

60.0000

12.0000

10-2-10

sl

loc

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

60

111060

10

113845

50

12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3C5A <i>12</i>		Purchased	No			130	Each	725.0000	18.0000			



6 Bolt



10-2-10 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	725	
111424	8	
111707	69	
112314	1	
113121	219	
113149	300	
113644	128	

AN44-C12 *1*



Eyebolt

Purchased

No

130

Each

24.0000

6.0000



10-2-10 sl (60)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	24	
111176	4	
111888	20	

*4
2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4C15 <i>with holes</i>		Purchased	No			130	Each	15.0000	6.0000		10-2-10	<i>sf</i>

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	15	
111303	3	
113618	12	

AN5C11 <i>xl</i>	Purchased	No				130	Each	32.0000	6.0000		10-2-10	<i>sf</i>
------------------	-----------	----	--	--	--	-----	------	---------	--------	--	---------	-----------

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	32	
111279	20	
113422	12	

AN5C15 <i>xl</i>	Purchased	No				130	Each	23.0000	6.0000		10-2-10 <i>sf</i>	<i>(6x)</i>
------------------	-----------	----	--	--	--	-----	------	---------	--------	--	-------------------	-------------

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	23	
10121	2	
110552	21	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960C10	AS1149C0363R	Purchased	No	Q51	017	130	Each	0.0000	42.0000			
WASHER												
AN960C516		Purchased	No			130	Each	218.0000	6.0000			
WASHER												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

218

102842

118

112532

100

D3454-1

Manufactured No

130 Each

23.0000 6.0000

Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

44588

2

46135

2

53745

19

Tuesday, February 02, 2010 1:50:28 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3454-3		Manufactured	No			130	Each	24.0000	12.0000			
												
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

48125

24

130

Each

14.0000

12.0000

12

10-2-10

sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

53697

14

130

Each

3.0000

24.0000

12

355606

10-2-10

sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

46138

3

D3454-5



Bushing

D3455-1



Spacer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3455-3		Manufactured	No			130	Each	21.0000	12.0000			
											10-2-10	sl
Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

48126

21

130

Each

0.0000

6.0000

D3462-041

Bracket Assembly

MS21043-3

Manufactured

No

Purchased

No

130

Each

4,398.000

18.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

4318

111819

70

112243

29

112314

4219

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS24665-227		Purchased	No			130	Each	131.0000	12.0000			
											10-2-10	sl
COTTER PIN												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 131

111359 1

113422 30

113845 100

MS24665-229		Purchased	No			130	Each	256.0000	12.0000			
											10-2-10	sl
COTTER PIN												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 256

111041 256

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
NAS1515H5		Purchased	No			130	Each	285.0000	6.0000			



Washer



10-2-10

sf

Warehouse	Loc Qty	Loc Code
Location		

OFFSHORE

FG 44

103286 17

103691 27

Main Warehouse

ST 241

109430 241

D3463-041

Manufactured No



Step Weldment Assembly

110 Each 1.0000 6.0000



10-2-10

6k

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST 1

53585 1

1354454 (4x)
355813 10-2-17 sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3443-043		Manufactured	No			110	Each	4.0000	6.0000			
Strut Weldment Assembly												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

54233

4

D3443-041

Manufactured No

110

Each

9.0000

6.0000



Strut Weldment Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

9

53696

1

54235

4

55610

4

D3443-9

Manufactured No

110

Each

10.0000

12.0000



Pin

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

48124

2

53502

8



10-2-10 sl
B55694



10-2-10 sl

B55810 (12) sp



B55812 10-2-10 sl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3454-7		Manufactured	No			110	Each	4.0000	12.0000			
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

46132

4

D3455-1

Manufactured

No

110

Each

3.0000

12.0000



Spacer



B55608 10-2-10 5/

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

46138

3

D3465-1

Manufactured

No

110

Each

59.0000

6.0000



Washer



10-2-10 5/ (6)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

59

41692

1

46134

58

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4CH3		Purchased	No			110	Each	23.0000	12.0000			
										10-2-10	sf	
SS Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

111978

23

AN4C14

Purchased

No

110

Each

13.0000

6.0000



BOLT

12

10-2-10

sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

110552

13

AN310-4

Purchased

No

110

Each

71.0000

6.0000



NUT

6

10-2-10

@

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

71

112969

9

113422

12

113845

50

6

Tuesday, February 02, 2010 1:50:28 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 02, 2010 1:50:28 PM

Work Order ID: 55819



Parent Item: D412-630-031



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 2/3/2010

Required Date: 2/15/2010

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN310-7		Purchased	No			110	Each	29.0000	6.0000			
										10-2-10	51	
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

103286

9

111916

20

MS24665-227

Purchased

No

110

Each

131.0000

6.0000



COTTER PIN

10-2-10 51

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

131

113422

1

113422

30

113845

100

MS24665-302

Purchased

No

110

Each

114.0000

6.0000



Cotter Pin

10-2-10 51 64

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

114

111359

14

113644

100

6

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NOTE: Date & initial all entries

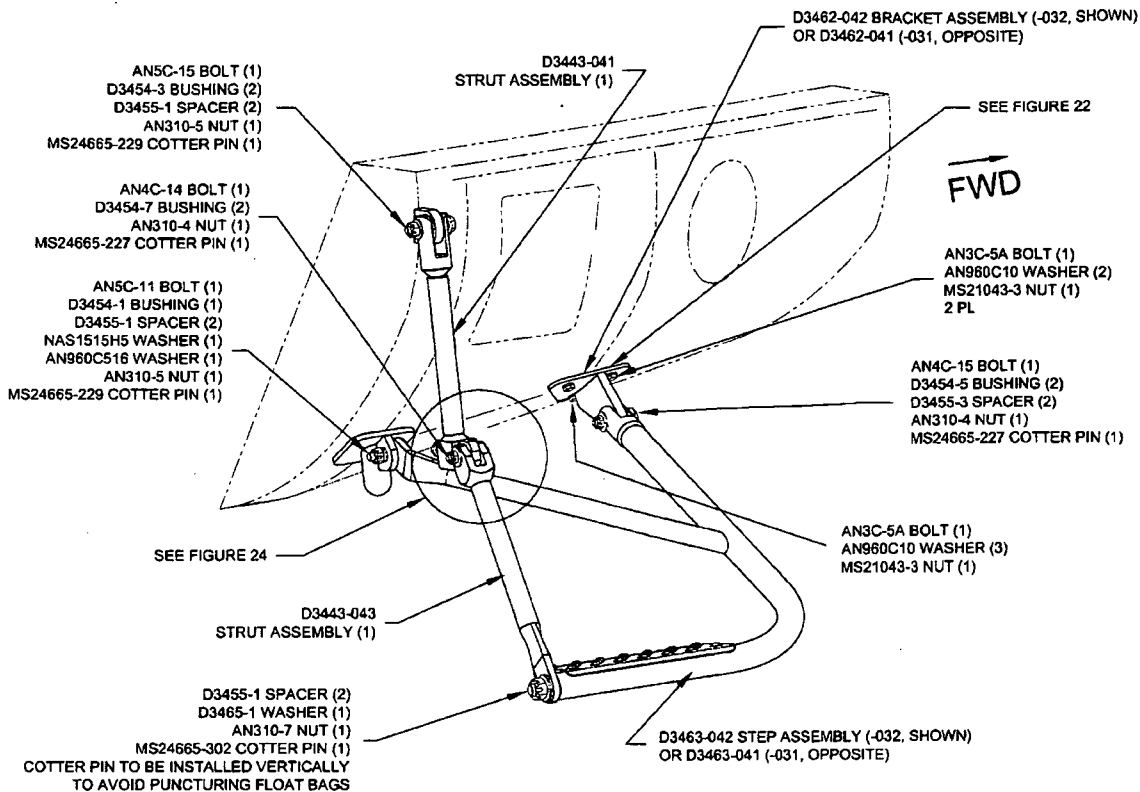


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

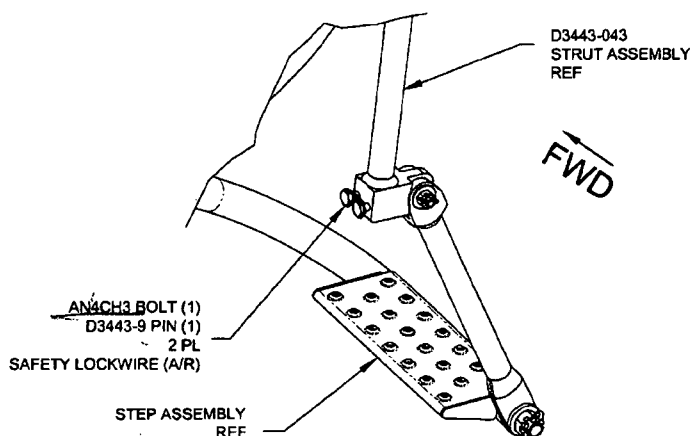


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Revision: M
Date: 08.12.12

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
12 1	1	D3443-041	STRUT ASSEMBLY
11 1	1	D3443-043	STRUT ASSEMBLY
10 2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6 (4)	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
2 1	1	D3465-1	WASHER
2 (1)	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2 (1)	2	MS24665-227 ✓	COTTER PIN -1
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

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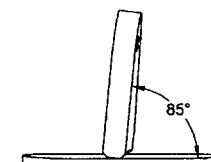
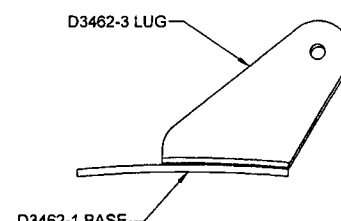
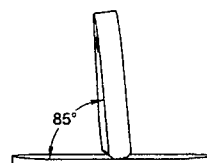
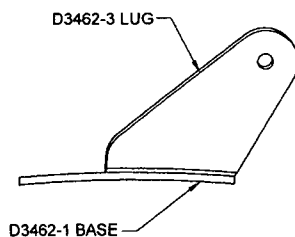
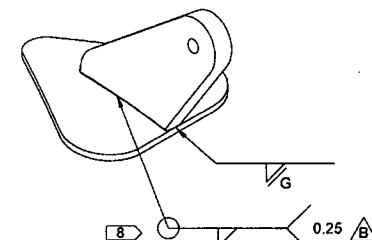
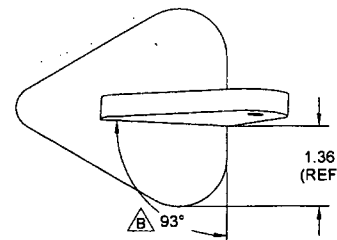
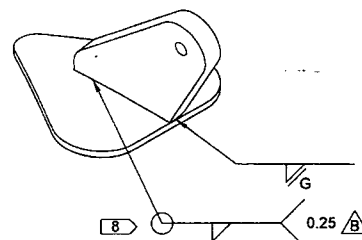
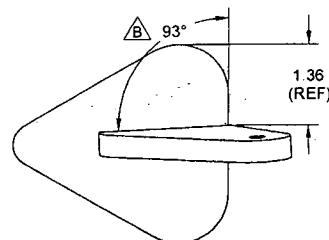
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REFERENCE ONLY



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

FILE
8.07.07

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	W.P. DC		
CHECKED	W.P. DC		
MFG. APPR.	W.P. DC		
APPROVED	W.P. DC		
DE APPR.	W.P. DC		
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 REV. C SHEET 1 OF 2 TITLE BRACKET ASSEMBLY SCALE 1:2 <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

Dart Aerospace Ltd

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